

Date: Tuesday, 4/18/2006 9:58:50 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 26651	
Estimate Number : 11375	
P.O. Number : N/A	Part Number : D33871
This Issue : 4/18/2006 S.O. No. : N/A	Drawing Number : D3387 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 26161	Material : N/A
Written By : <u>See Comment Below</u>	Due Date : 5/4/2006
Checked & Approved By : <u>06.04.18</u>	Qty: 4 Um: Each
Comment : Est:A 05.06.10 New Issue KJ/JLM Est:B 06.03.22 Split c'sink op. EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
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Comment: Qty.: 1.5685 f(s)/Unit Total : 6.2740 f(s)
 6061-T6 Bar .50" x 6.0"
 Material: 6061-T6/T651 (QQ-A-200/8)
 (M6061T6B0.500x06.000)
 Identify for D3387-1
 Batch: M100817

ml 06/04/29 4

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blank: 6.000" x 0.500" x 17.800" long

ml 06/04/29 4

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA511 and Dwg D3387
 Identify as D3387-1
 Tumble and Deburr NO sharp edges

ml 06/04/29 4

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 C'sink Ø0.375" as per Dwg D3387

ml 06/04/29 4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LS Date: 06/05/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/18/2006 9:58:50 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 26651

Part Number: D33871

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En 06/04/29

4

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/04/29 x4

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WA 30*

J.E. 06.05.01

4

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06/05/01

4

Job Completion



U 06/05/01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	26651
Description: Arm		Part Number:	D3387-1
Inspection Dwg: D3387	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.125	+/-0.010	R0.125	—			
0.105 0.125	+0.020/-0.000	0.133	✓			
Ø0.375 x100°	+/-0.010	Ø0.375 x100°	—			
R0.032	+/-0.010	R0.032	—			
0.500	+/-0.010	0.493	—			
0.500	+/-0.010	0.501	—			
7.577	+/-0.010	7.578	—			
R0.125	+/-0.010	R0.125	—			
Ø0.507	+0.000/-0.001	Ø0.507	—			
0.250	+/-0.010	0.249	—			
1.347	+/-0.010	1.347	✓			
2.000	+/-0.010	2.001	—			
1.000	+/-0.010	1.006	—			
Ø0.191	+0.005/-0.000	Ø0.191	—			
R0.300	+/-0.010	R0.306	✓			
2.033	+/-0.010	2.033	✓			
0.280	+/-0.010	—				can't find the measured
0.222	+/-0.010	—				can't find the measured
1.700	+/-0.010	1.702	—			

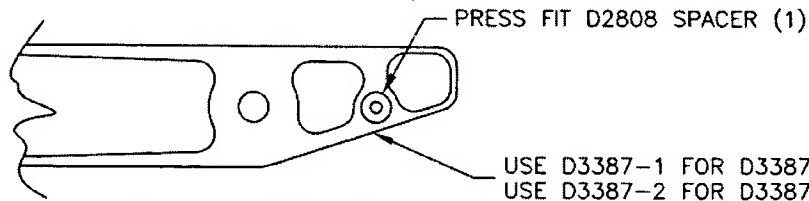
Measured by:	<i>mf</i>	Audited by:	<i>Ep</i>	Prototype Approval:	N/A
Date:	06/04/29	Date:	06/04/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue	KJ/JLM <i>AK</i>	<i>mf</i>

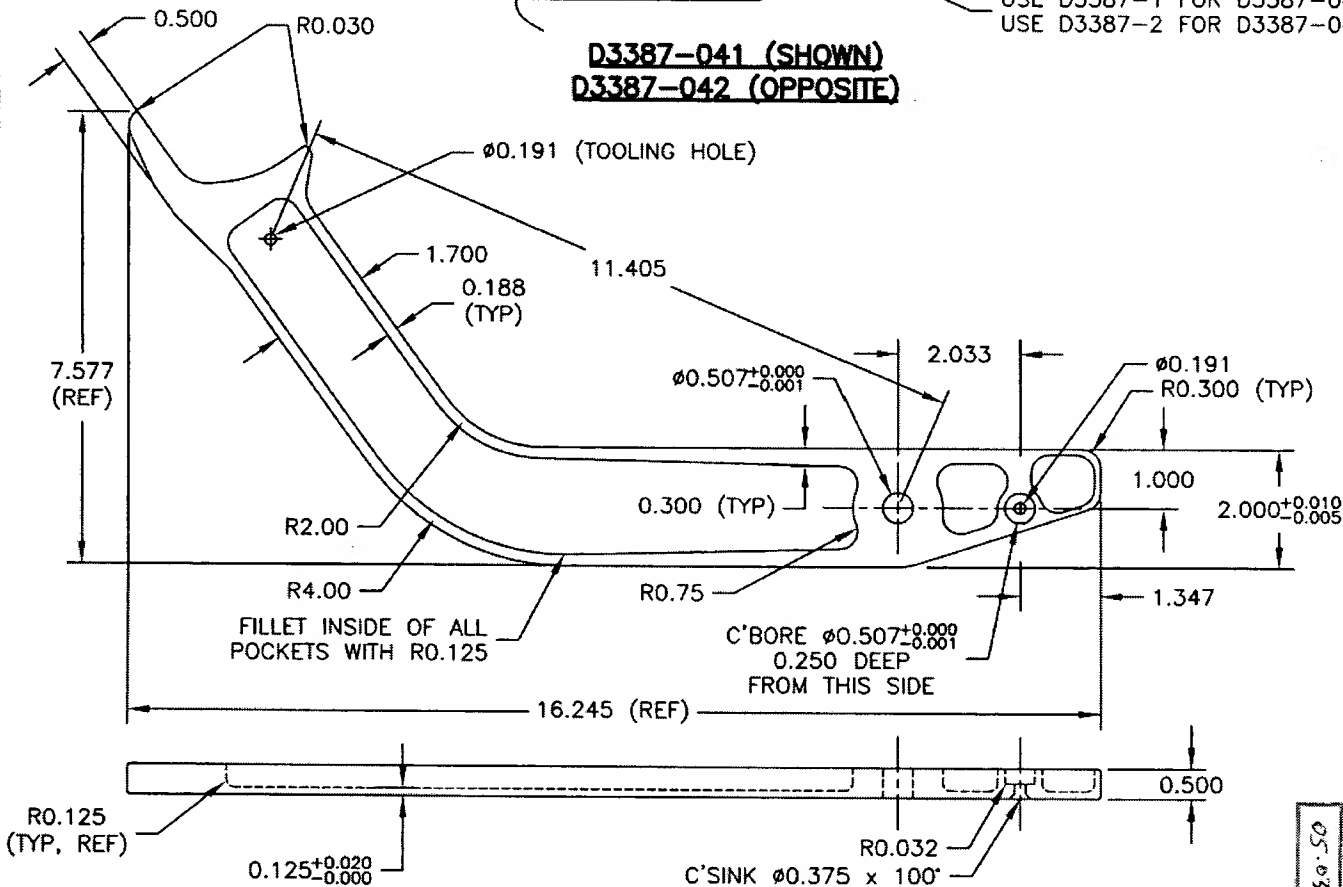


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3387	REV. A
DATE 05.01.18	TITLE ARM	SHEET 1 OF 1	SCALE 1:3
A	05.01.18	NEW ISSUE	

RELEASED
05.03.11



D3387-041 (SHOWN)
D3387-042 (OPPOSITE)



D3387-1 (SHOWN)
D3387-2 (OPPOSITE)

GENERAL NOTES

- MACHINE PER DRAWING FILE "D3387-A.DWG"
- MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11) 0.500 THICK (REF DART SPEC. M6061T6B0.500)
- DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES

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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 26651